

Date: Tuesday, 28/04/2009 2:22:36 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	212 BASKET BASE ASS'Y RH
Job Number :	47573B		
Estimate Number :	11543		
P.O. Number :		Part Number :	D3053042
This Issue :	28/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3053 REVB
First Issue :	/ /	Project Number :	
Previous Run :	47572B	Drawing Revision :	B
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	05/05/2009
Written By :		Qty:	1
		Um:	Each
Checked & Approved By :	<u>JUD09-04-28</u>		
Comment :	Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF Est Rev:D 08-08-29 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)
 304 SQ Tube.75x.75x.065W

45" inch END BAR SCRAP

1-Cut Rib from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

Batch: M111331

2-Drill holes in D3053-3 as per dwg D3053

SM 09/04/29

2.0	D31661	Basket Hoop
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Basket Hoop

Qty. 5 D3166-1

Batch: B47072 → 5xSM 09/04/29

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut 5 D2235-3 FROM D3166-1 using DT8365

2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995

SM 09/05/04

4.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing

Pick:

Qty Part Number Description Batch

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Job Number: 47573B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2327-3

Bushing

B44365 → 2x

LM 09/04/30

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Basket Hinge

Pick:

Qty Part Number Description
2 D2232-3 Hinge plate

Batch *B46626 → 2x*
B44365 → 2x

LM 09/04/30

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Mounting Bracket

Pick:

Qty Part Number
2 D2581

Description
Mounting Bracket

Batch

B46086 → 2x

LM 09/04/30

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)
Expanded Metal Flat Stai

Pick:

Qty Part Number
48sq.ft M304EX0.75-16F

Description
Expanded Metal

Batch

M111173(3)
M111444 (42.4) SAA 09-04-30

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

LM 09/05/04 / PD 09-05-06

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PC 09-05-07

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Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 47573B

Part Number: D3053042

Job Number:



Seq. #: Machine Or Operation: Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5-9/5/07 (X)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1st COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M111472
PRESSURE WASH

UMD/ BR.

09/05/08

2ND COAT

START time: 10:05

oven temperature: 400°

Finish time: 10:35

09/05/08

UMD/ BR

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/05/11

(1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

IMP 47573

PC 9/5/12 (1)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/12

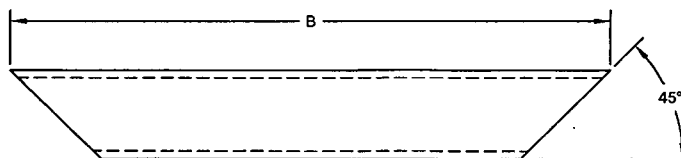
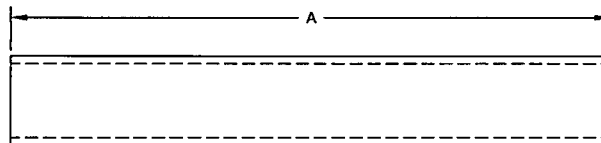
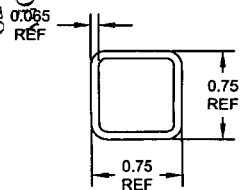
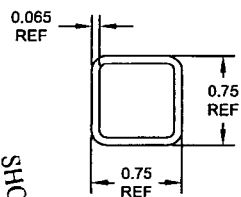
Job Completion



u 09.05.12

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



NO. 10
WORK ORDER
SUBJECT TO AMENDMENT
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0.065
REF



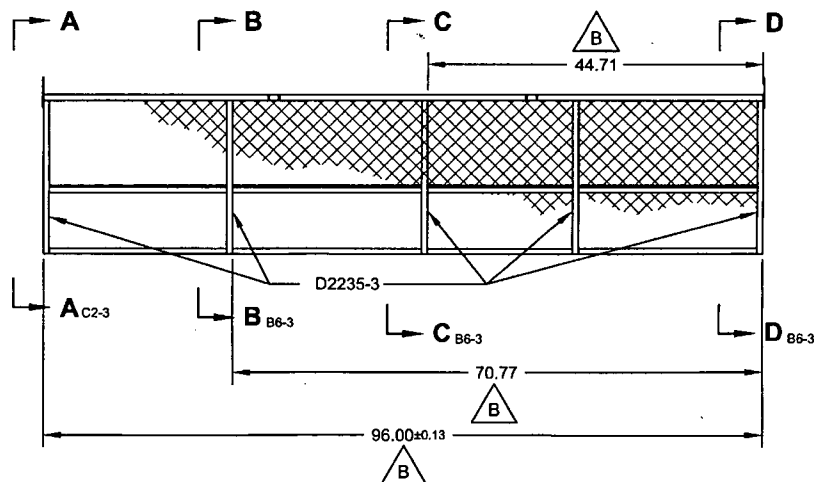
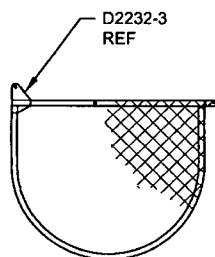
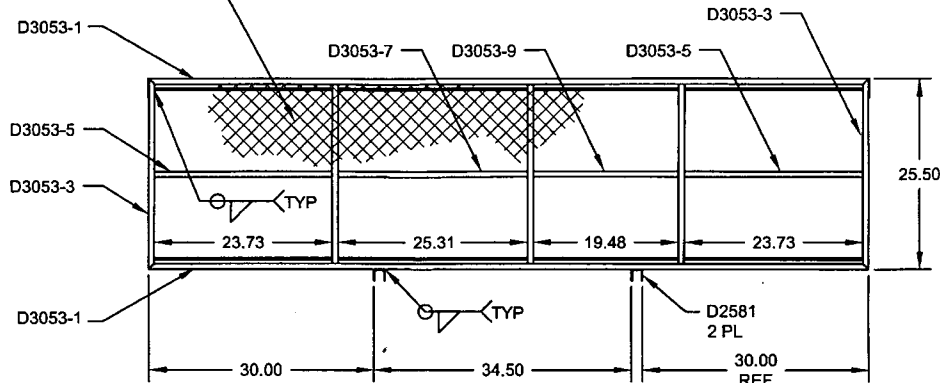
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

RELEASED
08.07.02

B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3053	SHEET 1 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME

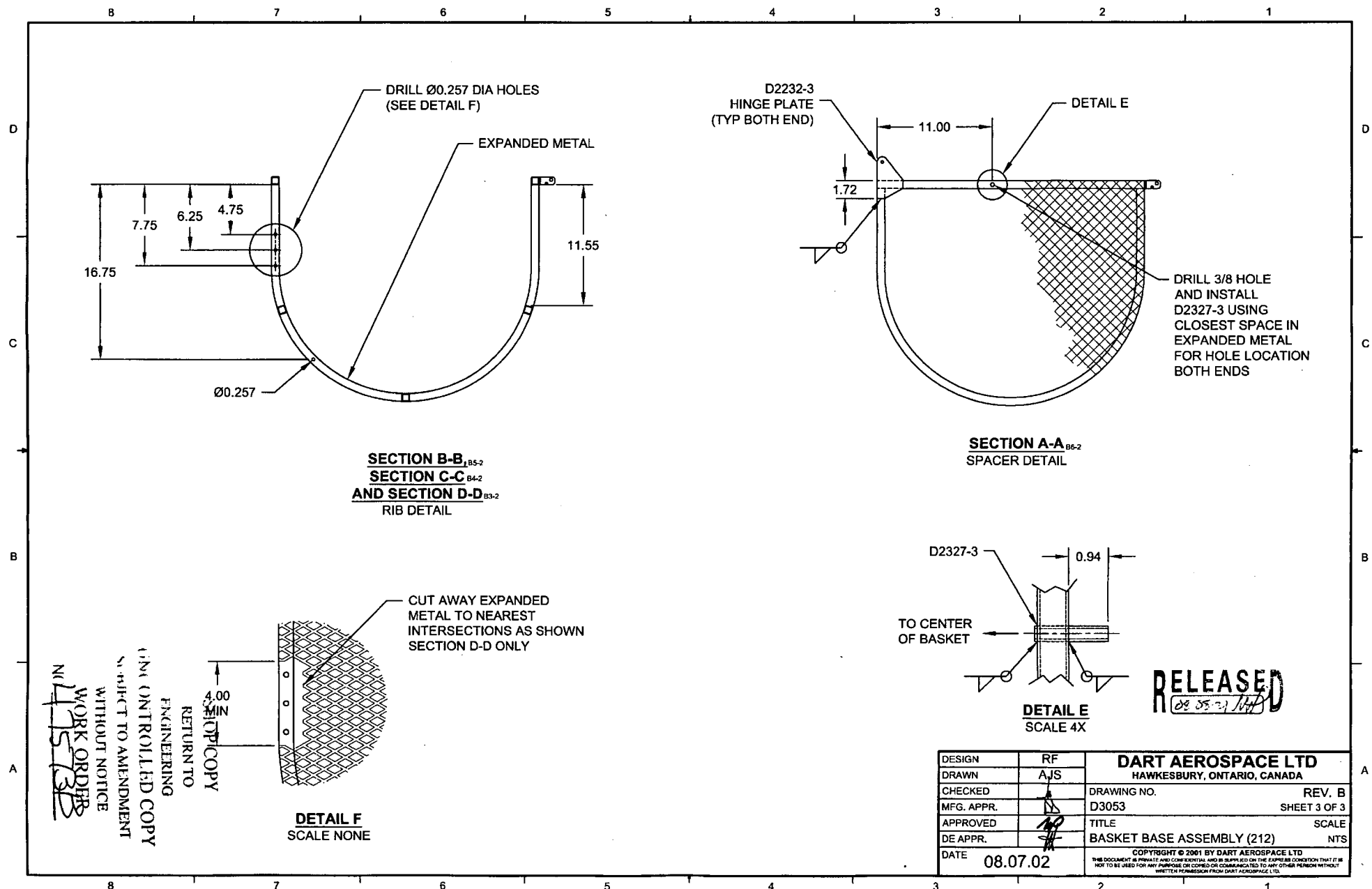


**D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)**

RELEASED
08.08.24

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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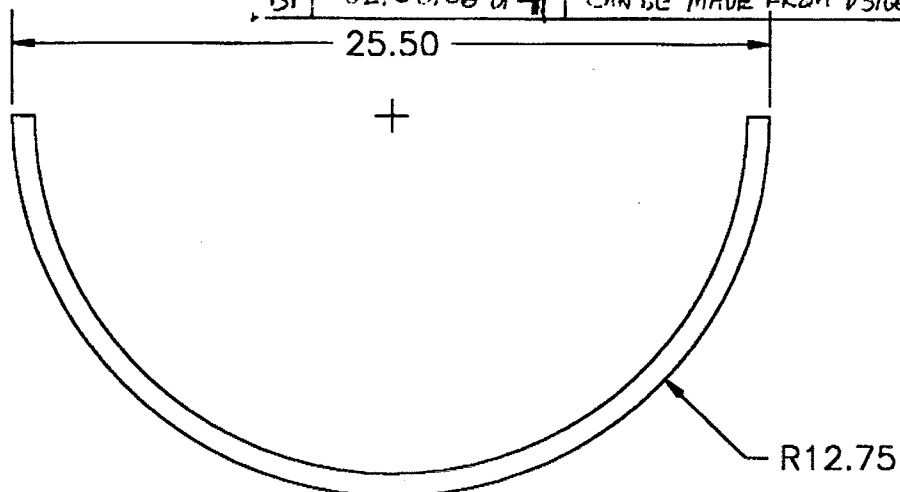




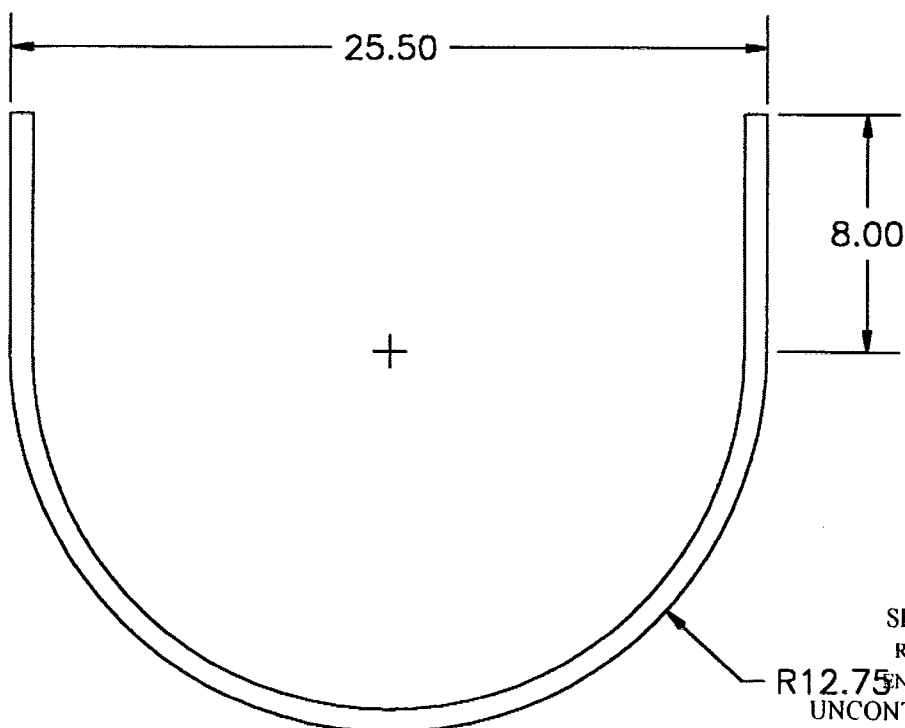
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2235	SHEET 1 OF 1
DATE		TITLE	SCALE
94:12:16		BASKET RIBS	

BI 02.08.06 11-11 CAN BE MADE FROM D3166-1


RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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